| Work Orde March-28-13 12 | |)179 | : | *991 | 179* | | | | | | Page 1 | 1 |
|---|----------------------|--|---|--|-------------------------------------|------------------------|---------------------------------------|---------------|------------------|------------------|----------------|---|
| Revision ID: | D3883-1 Saddle, Outb | oard LH | * | Accept | *N900 | 040 | 100 |) * s | Setup Star | IV. | S1* S2* | |
| Start Date: Required Date: Reference: | 3/21/13 3/27/13 | Start Qty: 8.00 Req'd Qty: 8.00 | *8* *8* | | Cust Item Customer: | | · · · · · · · · · · · · · · · · · · · | | - G | | | |
| Approvals: | | an: <u>M</u> び | • | | | ate: | | 1 | Run Star Stoj | 1/1 | R1* R2* | |
| Sequence ID/ Work Center II |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp | |
| Draw Nbr | Re | vision Nbr | | | | 3 | · · · · · · · · · · · · · · · · · · · | | | | | |
| D3883 | С | | À | | | | | | | | | |
| *100 *100* HAAS 1 HAAS CNC vertical | machine #1 | Double chec 1-Machine S Sheets 2-Machine S 3-Machine S | tch No. 49179 Sk by: 1 Step No 1 per Folio FA6 Step No 2 per Folio FA6 Step No 3 per Folio FA6 ER DWG AND FOLIO 7: AA | 0.00 0.00 315 and inspect per attached 341 and inspect per attached 315 and inspect per Dimens | J) / S I Dimension Dimension Sheets | -66-07 8-6-8 | | 8 | | | | |
| 105 | | | | 0.00 | | | | | . ' | | | |
| *105* Mill Conv | | Memo | | 0.00 | SLI | 368 | | 8 | | · <u></u> | | - |

Conventional Milling Machine

MILL KEYWAY AS PER DWG

| NCR: | Yes | / No | | u | | WORK ORDER NON- | COI | NFORN | MANCE / UPI | DATE | | QA Closed: | Da | ite: | |
|---------------|---------|----------------|---------------------------------------|----------|--------|--------------------------------|---------|----------|------------------------|---------------------|----------|---------------------------------------|-------------------------|----------|--------------------|
| 144 - alv Oad | | | | | | DISPOSITION | | · | | AGAINST D | EF | PARTMENT | PROCESS | | |
| Work Ord | | .,, | · · · · · · · · · · · · · · · · · · · | | | Rework | | 6 | Skid-tube | Crosstube | | | Water Jet | | Engineering |
| Part | No. | | | | | Scrap | - | | Machining | Small Fab | \dashv | | d. Eng. Coor. | | Quality Other |
| NCR | No. | | | | | Use-as-is Work Order Update | | | noforming Large Fab | Finishing Composite | | Rec/Stor | e/Packaging Supplier | - | Other |
| Root | | | | | Descri | ption of work order update | | Initial | Act | ion | | Sign & | | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Cr | nief Eng | Descr | ription | _ | Date | Verification | n | QC Inspector |
| Doc/Data | <u></u> | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | j | | | | |
| Material | L | | | | | | | | | | ļ | | | | |
| Setup | | | | 1 | | | İ | | | | | | | | |
| Other | | | | | | | ļ | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | i | | | | | | | | | | | į | |
| Unapproved | | | | <u> </u> | | | | | | | | · · · · · · · · · · · · · · · · · · · | | | |
| | | | | | | F | AUI | T CATE | GORY | | | | | | |
| Landi | ng (| Gear | | | | General | | 7 | | _ | | ! | | _ | 1 |
| i · | | Bending | | | | Bend | <u></u> | Grain | | - | | Ovalized | | _ | Pressure/Forced |
| | L | Centre N | ot Concer | ntric to | o/s | BOM/Route | <u></u> | Hardwa | | ļ | _ | Over/Under | | \vdash | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | | 4 | on Incomplete | | | Part Incorre | | | Weld |
| | | Crushed/ | Crimped. | | | Burrs | _ | -1 | ions Incomplete/l | Jnclear | | Part Lost/Mi | issing | | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | | 1 | | Part Moved | | | |
| | | Heat Trea | at . | | | Countersink | | Mislabe | | L | | Positioned V | = | | 7 |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | L | Misread | 1 | L | | Power Loss/ | Surge | | Other |
| | | Ripples ir | Bend | | | Drill Holes | | Offset | | | | | · | | |
| | 1 | Torque W | aves in E | xtrusio | n I | Drawing | l | Out of C | Calibration | | | | | | |

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 99179 Page 2 March-28-13 12:55:42 PM *N900040100* D3883-1 Accept Item ID: Setup Start **Revision ID:** Item Name: Saddle, Outboard LH *8* Start Qty: 8.00 **Start Date:** 3/21/13 **Cust Item ID:** Req'd Qty: 8.00 Required Date: 3/27/13 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Date: Approvals: Stop QC: SPC (Y/N): Date: Date: Reject Set Up/ Sequence ID/ Operation Tool ID Tool # Plan Accept Reject Insp. Number Stamp **Work Center ID** Description Qty Code Qty **Run Hours** QC2- Inspect parts off machine FAI/FAIB 0.00 110 Af13-06-07 SL 13-6-8 *110* 0.00 Memo Quality Control on Block 120 QC8- Inspect parts - second check 0.00 ·*120* 0.00 Memo Quality Control 8 d XX 13-6-10. Chemical Conversion Coat per QSI005 4.1 0.00 130 *130*

0.00

Memo

HandFinish

Hand Finishing

| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORM | MANCE / UPI | DATE | | | |
|----------------------|--|------------|------------|----------|----------|----------------------------|-----|----------|---------------------|------------------------|--------------|-------------------------------|--------------------|
| | | | | | | | | | | | QA Closed: | Date: | |
| Work Ord | er: | | | | | DISPOSITION Rework | | | Skid-tube | AGAINST DE | EPARTMENT, | /PROCESS Water Jet | Engineering |
| Part I | | - | | | · . | Scrap Use-as-is | | Therm | Machining noforming | Small Fab Finishing | | d. Eng. Coor. re/Packaging | Quality Other |
| NCR I | Vo. | - | | | | Work Order Update | _] | | Large Fab | Composite | J | Supplier | |
| Root | | | | | Descri | ption of work order update | 1 | Initial | | tion | Sign & | , i | |
| Cause | , | Date | Step | Qty | , | or Non-conformance | Cr | nief Eng | Desci | ription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | ļ | | | | | | |
| Equip/Tooling | - | | | | | | | | | | | | |
| Operator | _ | | 1 | | | • | ļ | | | | | | |
| Material | | | 1 | ļ | | | | | · | | | | |
| Setup | <u> </u> | | | | | | | | | | | | |
| Other | - | | | | | | | | | | | | |
| Process | _ | | | : | | | | | | | | | |
| Supplier Training | - | 1 | | | 1 | | | | | | | | |
| Unapproved | _ | | | | [| | | | - | • | | | |
| опарргочец | <u>. </u> | <u> </u> | | | <u> </u> | , , | AUI | LT CATE | GORY | | | <u> </u> | |
| Landi | ng (| Gear | | | | General | | | | | | | ** |
| | Ť | Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced |
| ł | Г | Centre No | ot Concer | ntric to | o/s | BOM/Route | | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | Г | Cracks | | | | Broken/Damaged | | Inspecti | ion Incomplete | | Part Incorre | ct | Weld |
| | Г | Crushed/ | Crimped. | | | Burrs | | Instruct | ions Incomplete/ | Unclear | Part Lost/M | issing | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | enance | | Part Moved | | |
| | | Heat Trea | it | | | Countersink | | Mislabe | eled | | Positioned V | Wrong | |
| | | Inspection | n Strip in | Tube | | Cut Too Short | | Misread | d . | | Power Loss/ | 'Surge | Other |
| | | Ripples in | Bend | | | Drill Holes | | Offset | | | | | |
| | | Torque W | /aves in E | xtrusio | n 🗌 | Drawing | | Out of 0 | Calibration | | | | |

Out of Sequence

Outside Dimensions

DQA: ____Date: ____

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| Work Ord March-28-13 | | 179 | | *991 | 179* | | | Page 3 |
|--|-----------------------|---|--------------------|--|-------------------------|-----------|---------------|---------------------------------------|
| Item ID: Revision ID: | D3883-1 | | | Accept | *N90004010 |)()* Setu | p Start | *NS1* |
| Item Name: | Saddle, Outbo | oard LH | | | | | Stop | *NS2* |
| Start Date: Required Date Reference: | 3/21/13 e: 3/27/13 | Start Qty: 8.00 Req'd Qty: 8.00 | *8* *8* | | Cust Item ID: Customer: | | ٠. | |
| Approvals: | Process Pla | an: | Date: | Tooling: SPC (Y/N): | Date: | Run — | Start Stop | *NR1* *NR2* |
| Sequence ID/ Work Center 140 *140* Powdercoat Powder Coating 150 *150* QC Quality Control | | Operation Description White Gloss(Ref.4.3.5.1) Memo START TIM OVEN TEM FINISH TIM QC3- Inspect Part Finish Memo | IE: IPERATURE: IE: | Set Up/ Run Hours 0.00 0.00 0.00 0.00 | Tool ID Tool # Plan | le Qty Q | 9ty 1 | Reject Insp. Number Stamp L 13/06/13 |

160

Identify as per dwg & Stock Location: 57429 0.00

160

Packaging

Packaging

Memo

0.00

8x Mill. 13-06-11

| NCR: | Yes | / No | | | | WORK ORDER NON- | CON | VFORM | MANCE / UPDATE | | QA Closed: | Date: | |
|---------------|----------|---------------------------------------|-----------|----------|------------------|--|--------------|---------|---|----------|------------------------------|---|---------------------------|
| | | · · · · · · · · · · · · · · · · · · · | | | | DISPOSITION | Ĩ | i | ΔGAIN | ST DE | PARTMENT | | |
| Work Ord | er: | | | | | DISPOSITION | , | | · | | 1 /4.(((((6.4)) | | i — |
| Part NCR | | | | | | Rework Scrap Use-as-is Work Order Update | | Thern | Skid-tube Crosstul Machining Small F. noforming Finishi Large Fab Composi | ab ng | ł | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | | <u> </u> | T | | Descri | ption of work order update | | nitial | Action | | Sign & | | |
| Cause | | Date | Step | Qty | 1 | or Non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Doc/Data | Τ | | 1 | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | - | |
| Operator | | : | | |] | | | | | | | | |
| Material | | } | | | 1 | | | | | | | | |
| Setup | | | | | | | | | | | | | |
| Other | <u>_</u> | | | | | | | | | | | | |
| Process | | | | | | | | | | | | , | |
| Supplier | <u> </u> | | | | | | | | | | | | |
| Training | \vdash | - | | | | | | | | | | | |
| Unapproved | <u> </u> | | <u> </u> | <u> </u> | <u> </u> | r | | T CATE | COBY | | 1 | <u> </u> | |
| Land | ina f | Goor | | | | General | AUL | .: CATE | JUNI | | | | |
| Lanu | L S | Bending | | | · [| Bend | Г | Grain | | | Ovalized | | Pressure/Forced |
| | \vdash | Centre N | ot Conce | ntric to | | BOM/Route | | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | H | Cracks | or conicc | ,,,,,,, | ~~~ | Broken/Damaged | - | 4 | on Incomplete | | Part Incorre | <u> </u> | Weld |
| | \vdash | Crushed | Crimped | | | Burrs | - | i ` | ions Incomplete/Unclear | | Part Lost/M | issing | Wrong Stock Pulled |

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio DQA:

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| Work Orde | | | | *991 | 179* | | | | | | Page 4 |
|---|-------------------------|---|----------------------|------------------------------|--------------------------|------------|--------------|---------------|-----------------|------------------|----------------|
| Revision ID: | D3883-1 Saddle, Outb | poard LH | | Accept | *N900 | 040 | 100 |)* s | etup Star | iV | S1* S2* |
| Start Date: Required Date: Reference: | 3/21/13 3/27/13 | Start Qty: 8.00 Req'd Qty: 8.00 | *8* *8* | | Cust Item I Customer: | D: | | | | | |
| Approvals: | Process P QC: | lan: | Date: | Tooling: SPC (Y/N): | 7 | ate: | | R | kun Stai Sto | | R1* R2* |
| Sequence ID/ Work Center II 170 *170* QC |) | Operation Description QC21- Final Inspection Memo | - Work Order Release | Set Up/ Run Hours 0.00 | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |

pl 13-010-11

| Work Order: Part No. | NCR: | Yes | / No | | | | WORK ORDER NON- | CO | VFOR | MANCE / UPI | DATE | 04 (1 | Data | |
|--|------------|----------|------|-----------|-----------|-------------------|--------------------|----------|---------|---------------|-------------|------------|-------------------|---------------------------------------|
| Part No. Skid-tube Skid-tube Skid-tube Small Fab Prod. Eng. Coor Quality Description of work order update Chief Eng Description of work order update Chief Eng Description of work order update Chief Eng Description Date Verification QC Inspector Doc/Oaxa Cause Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Oaxa Cause Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Oaxa Cause Chief Eng Description Date Verification QC Inspector Date Chief Eng Description Date Verification QC Inspector Date Da | | | | | | | | | | 3 - NNA | | QA Closed: | Date: | |
| Rework Scrap Use-as-is Work Order Update Use-as-is Work Order update Cause Date Step Qty or Non-conformance Order update Cause Doc/Data Gain Holder Gain | Work Ord | or. | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | • |
| Part No. | VVOIR OIG | ٠ | | | | | Rework | ۱ ۱ | | Skid-tube | Crosstube | 7 | Water Jet | Engineering |
| NCR No. | Part I | No. | | | | | ļ —— | 1 | 1 | | } | Pro | — | · · · · · · · · · · · · · · · · · · · |
| Root Cause Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator | | | | | | | <u> </u> | | | ~ | Finishing . | Rec/Stor | re/Packaging | Other |
| Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data (ξωμ)/Tooling Image: Conformation of Conformance Image: Conformance of Conformance of Conformance Image: Conformance of | NCR I | ۷o. | | | | | Work Order Update |] | | Large Fab | Composite |] | Supplier | |
| Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data (ξωμ)/Tooling Image: Conformation of Conformance Image: Conformance of Conformance of Conformance Image: Conformance of | | | | · | | | | | | | | | | |
| Doc/Data Equip/Tooling Operator Operat | | | | | | | • | | | | | _ | V - 161 - 112 - 1 | 061 |
| Equip/Tooling Operator | | | Date | Step | Qty | (| or Non-conformance | Ch | net Eng | Descr | ription | Date | Verification | QCInspector |
| Operator Material Setup Other | | | | | | | | İ | | | | | | |
| Material Setup Other Oth | | | | | | | | | | | | | | |
| Setup Other | | \vdash | | | | | | | | | | | | |
| Other Process | | Ш | | | | | | | | | | , | | |
| Process Supplier Training Duapproved Supplier Su | | \vdash | | | | | | | | | | | 1 | |
| Supplier Training Unapproved FAULT CATEGORY Landing Gear General Grain Ovalized Pressure/Forced Pressure/Forced Over/Under tolerance Temperature/Cure Over/Under tolerance Temperature/Cure Over/Under tolerance Over/Under toleran | | \vdash | | | | | | | | | | | | |
| Training Unapproved | | \vdash | | | ļ | | | | | | | | | |
| Landing Gear General Grain Ovalized Pressure/Forced Hardware Over/Under tolerance Temperature/Cure General Over/Under tolerance Temperature/Cure Over/Under tolerance Temperature/Cure Over/Under tolerance Over/Under toleran | | Н | | | | | | | | | | | | |
| Landing Gear General General Ovalized Pressure/Forced Over/Under tolerance Temperature/Cure Outline | _ | \vdash | | | | | | | | | | | | |
| Landing Gear Bending Bending Centre Not Concentric to O/S Broken/Damaged Crushed/Crimped. Burrs Contamination Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Bend Grain Grain Ovalized Over/Under tolerance Hardware Over/Under tolerance Inspection Incomplete Hardware Instructions Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Part Lost/Missing Wrong Stock Pulled Part Moved Positioned Wrong Power Loss/Surge Other Other | Unapproved | | | <u>l</u> | | | | <u> </u> | TCATE | CORY | | <u> </u> | | |
| Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset | 1 4 | | | | · | | | AUL | .i CATE | JORT | | | | |
| Centre Not Concentric to O/S Cracks Broken/Damaged Inspection Incomplete Crushed/Crimped. Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend BOM/Route Hardware Dover/Under tolerance Hardware Over/Under tolerance Part Incorrect Weld Weld Wrong Stock Pulled Part Lost/Missing Wrong Stock Pulled Maintenance Part Moved Positioned Wrong Power Loss/Surge Other Offset | Landi | | ı | | | | 7 | Γ | l Grain | | | Ovalized | [- | Pressure/Enroed |
| Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Orill Holes Offset | | Н | 1 | at Cancar | ntric to | | 4 | - | - | uro. | - | 4 | tolerance | -1 |
| Crushed/Crimped. Burrs Instructions Incomplete/Unclear Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Drill Holes Instructions Incomplete/Unclear Maintenance Maintenance Mislabeled Mislabeled Misread Offset Part Lost/Missing Wrong Stock Pulled Part Lost/Missing Part Lost/Missing Part Lost/Missing Part Lost/Missing Pover Loss/Surge Other Offset | | H | ľ | of Concer | iitiic to | ^{0/3} - | • | \vdash | 4 | | | -1 | | - |
| Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset | | \vdash | | Crimpad | | - | -i | \vdash | 4 ' | • | Unclear | -1 | | - 4 |
| Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset | • | - | | cimpeu. | | - | ╡ | - | - | | - I | | |] o 8 o. c.o |
| Inspection Strip in Tube Ripples in Bend Cut Too Short Offset Power Loss/Surge Other | | Н | | ıt | | <u> </u> | 4 | | - | | - | 4 | Vrong | |
| Ripples in Bend Drill Holes Offset | | - | | | Tube | · | 4 | \vdash | 4 | | <u> </u> | | | Other |
| | | _ | | | TUDE | | = | | 4 | • | <u>L</u> | | | .1 |
| | | \vdash | | | Extrusio | n - | Drawing | \vdash | 4 | Calibration | | | | |

Out of Sequence

Outside Dimensions

DQA: _____Date: _____

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

March-28-13 12:55:42 PM

Work Order ID:

99179

Parent Item:

D3883-1

Parent Item Name:

Saddle, Outboard LH

Start Date: 3/21/13

Required Date: 3/27/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP RevA: New issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-015 | | Manufactured | No | | | . 100 | Each | 9.0000 | 1 | 2 8/1 | | | |
| Saddle Billet | | | | | | | | | | 13 | 13-06-0 |) 🖈 | |
| | | | | Location | | Loc Oty | <u>Lo</u> | c Code | | | | | |
| | | | | MAT040 | | 9 | | | | | | | |
| | | | | 9379 | 90 | 9 | | | | | | | |

99146

8

| NCR: | Yes | 1. | No |
|------|-----|----|----|
| | | | |

WORK ORDER NON-CONFORMANCE / UPDATE

| | | | → |
|------|-------|---|----------|
| DOA. | Data | * | |
| DQA: | Date: | | |
| | | | |
| | | | |

| | | | | | | | | | QA Closed: | Date: | |
|---------------------------------|------------|------------|-------------|---------|---|-----------|---|---|--------------|--|---------------------------|
| Work Order | r: · | | 40. | | DISPOSITION | ' | | AGAINST DE | PARTMENT | PROCESS | · |
| Part No | 0. | | | | Rework Scrap Use-as-is Work Order Update | ł I | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | -{ | Water Jet d. Eng. Coor. e/Packaging Supplier | Engineering Quality Other |
| Root | | | | Descri | ption of work order update | Initial | , | Action | Sign & | | |
| Cause + | Date | Step | Qty | . (| or Non-conformance | Chief Eng | De | scription | Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator | | · | | | | | | | | | |
| Material | 1 | | | | | | , , | | | | 49 |
| Setup | | | | | | | | | , | | |
| Other | | | | | | | | | | | |
| Process | | | * €. | | | | | | | | |
| Supplier | | | | | | | i | • | | | |
| Training | | | | | | | | | | · | 1 |
| Unapproved | | | | | | | | | | | |
| | | | | | FA | AULT CATE | GORY | | | | |
| Landing | g Gear | - " | | | General | | | <u></u> | _ | , | _ |
| | Bending | | | | Bend | Grain | | | Ovalized | | Pressure/Forced |
| | Centre No | ot Concer | ntric to (| D/S | BOM/Route | Hardwa | are | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | | | | Broken/Damaged | Inspect | ion Incomplete | <u> </u> | Part Incorre | j - | Weld . |
| | Crushed/0 | Crimped. | | L | Burrs | Instruc | tions Incomplet | te/Unclear | Part Lost/Mi | ssing | Wrong Stock Pulled |
| | Cuffs | | | <u></u> | Contamination | Mainte | enance | | Part Moved | | |
| | Heat Trea | t | | | Countersink | Mislab | eled | | Positioned V | Vrong | · · |
| | Inspection | n Strip in | Tube | | Cut Too Short | Misrea | ď | | Power Loss/ | Surge | Other |
| | Ripples in | Bend | | | Drill Holes | Offset | | | | | |
| | Torque W | aves in E | xtrusion | ۱ 🗀 | Drawing | Out of | Calibration | | | | |
| . [| Turning S | equence | | | Finish | Out of | Sequence | | | | |
| ·Γ | Wave/Tw | ist in Tub | oe . | | Folio | Outside | e Dimensions | | | | |

| DART AEROSPACE LT | 'D | • | Work Order: | 99179 |
|-----------------------------|---------|---|--------------|-------------|
| Description: Saddle, Outboo | ard, LH | | Part Number: | D3883-1 |
| Inspection Dwg: D3883 | Rev. C | | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing and record below:

| | | | | Re | corded Act | ual Dimensi | ons | | |
|-----------|--------|-----------|-------------------|-------|------------|-------------|--------|----|--|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | Ву | Date |
| Α | 2.870 | 2.880 | | 2.875 | 2.875 | 2.875 | 2.875 | | |
| В | 1.433 | 1.443 | | 1.437 | 1.437 | 1.437 | 1.437 | | |
| C | 0.638 | 0.658 | | .646 | .4475 | 3648 | -647 | | |
| D | 3.895 | 3.905 | | 3.900 | 3.900 | 3,900 | 3.900 | 1. | |
| E | 0.257 | 0.262 | | e 258 | .258 | 758 | .258 | | |
| F | 0.605 | 0.625 | | . 619 | .6155 | .6155 | -615 | | · |
| G | 1.120 | 1.130 | | 1.125 | 1.125 | 1.125 | 1.175 | | |
| H | 2.245 | 2.255 | | 2.250 | 2.250 | 2.250 | 2.250 | | |
| <u> </u> | 2.000 | 2.020 | | 2.001 | 2.0027 | 2.0027 | 2.0027 | | |
| J | 0.140 | 0.165 | | .150 | 0146 | 0147 | 148 | | |
| K | 0.240 | 0.260 | | . 246 | .245 | 0244 | -2747 | | |
| <u>L.</u> | 0.115 | 0.135 | | 6173 | 0175 | . 74 | 6125 | | |
| M | 0.140 | 0.165 | | = 148 | 147 | 1147 | -146 | | |
| N | .0.720 | 0.780 | | .770 | 3770 | 770 | .770 | | |
| 0 | 0.240 | 0.260 | | e 250 | -251 | -251 | 251 | * | ************************************** |
| Р | 0.110 | 0.140 | | 140 | .140 | ,140 | .140 | | |
| Q | 0.178 | 0.198 | | o188 | . 188 | .188 | .188 | | |
| R | 2.825 | 2.885 | | 2.855 | 2.855 | 2.855 | 2.855 | | |
| S | 0.316 | 0.321 | | ,316 | . 316 | ,316 | . 316 | | ` |
| T | 0.990 | 1.010 | | 1.001 | 1-000 | 1-000 | 1000 | | |
| U | 1.745 | 1.755 | | 1.750 | 1,750 | 1750 | 1,750 | | |
| V | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | | |
| W | 1.245 | 1.255 | | 1,250 | 1.250 | 1,250 | 250 | | |
| Χ | 0.490 | 0.510 | | 494 | 498 | 497 | -494 | | |
| Υ | 1.220 | 1.280 | | 1-250 | 1,250 | 1-250 | 1-250 | | |
| Z | 2.495 | 2.505 | | 2.500 | 2-500 | | 2-500 | | |
| AA | 0.313 | 0.318 | | .314 | . 314 | 314 | .314 | ' | |
| AB | 0.020 | 0.040 | | -030 | -030 | -030 | -030 | | |
| AC | 0.760 | 0.765 | | 760 | . He0 | .760 | | | * |
| AD | 0.215 | 0.220 | | -217 | -217 | 2017 | 760 | | . 4 ` |
| AE | 1.265 | 1.285 | | 1.246 | 1.2677 | 1.268 | 1.2682 | | |
| AF | | | | | | | | | |
| | Acc | ept/Rejec | et | | | | | | |

| | | | | • | |
|--------------|----------|---------|------------|----------|--|
| Measured by: | S | | Audited by | GM | |
| Date:1 | 13-06-07 | 13-6-08 | Date: | 13/06/16 | |
| | 7 | | | | |

| Rev | Date | Change | | Revised by | Approved |
|-----|----------|--------------------|----|------------|----------|
| Α | 09.10.22 | New Issue | K. | KJ . | JLM / |
| В | 09.11.25 | Dimension AE added | : | KJ X | 111 |
| | | | | 7/- | 11-1-1-1 |

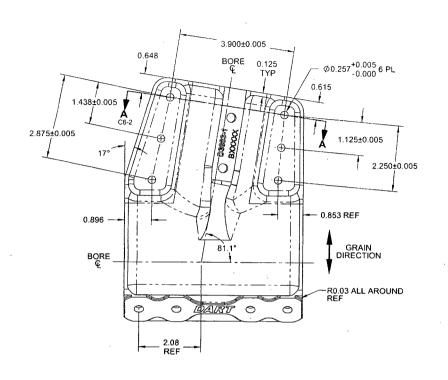
| DART AEROSPACE LTD | Work Order: | 99179 | |
|-----------------------------------|--------------|-------------|--|
| Description: Saddle, Outboard, LH | Part Number: | D3883-1 | |
| Inspection Dwg: D3883 Rev. C | | Page 1 of 1 | |

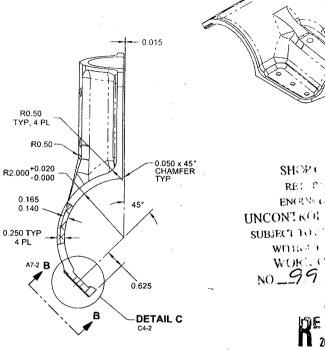
Inspect dimensions highlighted on inspection sheet drawing and record below:

| 70 2.3 33 1.3 38 0.4 95 3.9 57 0.2 05 0.4 20 1.45 2.3 40 0.4 40 0.2 15 0.3 | 380 380 443 558 905 262 525 30 255 920 665 260 335 66 | Go/No Go Gauge | 5 \$ 2.875 1.438 -647 3.900 .258 -615 1.124 2.250 003 -148 -248 | 68 2.875 1.438 -648 3.900 .258 -615 1.25 2.250 2.003 -148 | 7 8 2.875 1.438 .648 3.900 .258 .05 .250 2.03 | 8 19 2.875 1.438 2.900 .258 -615 2.250 2.250 2.004 | Ву | Date |
|---|--|--|---|---|---|---|---|---|
| 33 1.38 0.49 3.5 3.5 0.5 0.40 0.20 1.00 1.0 | 1443 658 905 262 325 130 255 220 65 260 | | 1.438 -647 3.900 .258 -615 1.124 2.250 2.003 | 3,900 ,258 -615 1,25 2,250 | 1.438 6.48 3.900 .258 - 6.15 1.125 2.250 2.03 | 1438 2.900 .258 -615 1.125 2.250 | | |
| 38 0.0 95 3.9 57 0.2 05 0.4 20 1. 45 2.2 40 0. 40 0. 40 0. 40 0. 40 0. 40 0. | 658 605 262 625 130 255 020 165 260 | | 1.438 -647 3.900 .258 -615 1.124 2.250 2.003 | 3,900 ,258 -615 1,25 2,250 | 1.438 6.48 3.900 .258 - 6.15 1.125 2.250 2.03 | 1438 2.900 .258 -615 1.125 2.250 | | |
| 95 3.9 57 0.1 95 0.0 90 1. 45 2.1 90 2.0 40 0.1 91 0.1 91 0.1 | 905 262 525 130 255 920 165 260 | | 3.900 .258 .615 1.124 2.250 2.003 | 3,900 ,258 -615 1,25 2,250 | 3,900 .258 .65 [1,25 2,250 2,03 | 2.900 .258 -615 [125] 2.250 | | |
| 57 0.3 05 0.4 20 1. 45 2.3 00 2.6 40 0.3 40 0.3 40 0.3 | 262 525 130 255 020 165 260 | | .258 -615 1.124 2.250 2.003 | 3,900 ,258 -615 1,25 2,250 2,003 | 3.900 .258 .615 1.125 2.250 2.003 | 3.900 .258 -615 []25 2.250 | | |
| 05 0.0 20 1. 45 2.3 00 2.0 40 0.2 40 0.2 15 0.3 | 325 130 255 020 165 260 | | .258 -615 1.124 2.250 2.003 | ,258 1,25 2,250 2,003 | 1,125 2-250 2-03 | .258 [125] 2.250 2.050 | | |
| 20 1.7 45 2.1 00 2.0 40 0.7 40 0.2 15 0.7 | 130 255 020 165 260 | | 7.124 2.250 2.003 | -615 1.125 2.250 2.003 | 1,125 2-250 2-03 | 1.125 2.250 2.004 | | |
| 15 2.2 00 2.0 10 0.2 10 0.2 15 0.2 | 255 020 165 260 35 | | 1.124 2.250 2.003 | 2250 | 1.125 2-250 2-03 | 1.125 2.250 2.004 | | |
| 00 2.0 40 0.2 40 0.2 15 0.2 40 0.2 | 020 165 260 35 | | 2.250 2.003 | 2.003 | 2-250 | 2-004 | | |
| 10 0.1 10 0.2 15 0.1 10 0.1 | 165 260 35 | | 2,003 | 2.003 | 2.003 | 2-004 | | ····· |
| 10 0.2 15 0.2 10 0.2 | 260 35 | | 1_148 | | 11111 | | | |
| 15 0.1 10 0.1 | 35 | | 7040 | | _ 144 | _149 | | |
| 0.1 | | | レベンスロ | -248 | -247 | 248 | | |
| | 65 | | 6125 | 125 | -124 | 126 | | |
| | | | -148 | -125 -148 | 1-147 | 126 148 - 770 | | |
| 20 0.7 | '80 | | a 770 | -770 | | 450 | | |
| | 260 | | -251 | -251 | 7770 | -248 | | |
| 0 0.1 | 40 | | 6140 | 1140 | 140 | .140 | | |
| | 98 | | .188 | . 188 | .188 | . 188 | | |
| | 85 | | 2.855 | 2.855 | 2.855 | 2.855 | | |
| | 21 | | .316 | .316 | ,316 | عاد ، | | |
| 0 1.0 | 10 | | 1-000 | 1001 | 1,001 | 1-000 | | |
| 5 1.7 | 55 | | 1750 | 1.750 | 15450 | 1750 | | *************************************** |
| 0 6.0 | 10 | | 6-000 | 6.000 | 6.000 | 6 000 | | |
| 5 1.2 | 55 | | 6-900 | 1-250 | 1-250 | 1250 | | |
| 0.5 | 10 | | 1.497 | -494 | 500 | 6,000 1.250 -419 | | F |
| 0 1.2 | 80 | | 1-250 | 1.250 | 1-250 | 1,250 | | |
| 5 2.5 | 05 | | 2.500 | 2.500 | 2-500 | 2-500 | | |
| 3 0.3 | 18 | | .314 | 314 | | 314 | | |
| | 40 | | -030 | -UZV | | -030 | | |
| 0 0.7 | 65 | | .740 | .760 | | 760 | | <u>.</u> |
| 5 0.2 | 20 | | 2017 | 2017 | 2017 | JAM | | |
| | 85 | | | 1268 | 1.268 | 7.068 | | |
| 5 1.2 | | | | · · · · · · · · · · · · · · · · · · · | /-XV4 | / -1× VU | | |
| 5 1.2 | Reject | | · · · · · · · · · · · · · · · · · · · | | | | | |
| (| 0 0.0 0 0.7 5 0.2 5 1.2 | 0 0.040 0 0.765 5 0.220 6 1.285 ccept/Reject | 0 0.040 0 0.765 5 0.220 6 1.285 ccept/Reject | 3 0.318 344 0 0.040 -030 0 0.765 740 5 0.220 217 6 1.285 7-268 | 3 0.318 314 314 314 314 30 0.040 -030 -030 -030 30 30 30 30 30 30 30 30 30 30 30 30 | 3 0.318 314 314 314 314 0.040 0.040 0.765 760 760 760 760 760 760 760 760 760 760 | 3 0.318 3 4 314 314 314 314 0.040 0.040 0.765 760 760 760 760 760 760 760 760 760 760 | 3 0.318 314 314 314 314 314 314 314 314 314 314 |

| | | // // | | | | |
|---|--------------|----------|--------|------------|-------|-----|
| | Measured by: | | / SL | Audited by | (-) | |
| Į | Date: | 13-06-07 | 13-6-8 | Date: | 13/06 | 110 |
| | | | 1 | | | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------|-------------|-----------|
| Α | 09.10.22 | New Issue | KJ | JLM / |
| В | 09.11.25 | Dimension AE added | KJ X/L | 11 |
| | | | | 1 Company |





RE: " ENGINE LL UNCONTROL TO COM SUBJECT TO A SERVE OF WITHOUT STOLE WORL ONLY NO. 99179 MC5 13-03-28

D3883-1 SADDLE, OUTBOARD LH (SHOWN) D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

NOTES:
1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010

7) WEIGHT: 1.00 lbs 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

| С | ADD R1 | .265 (ZN D6-2) | | RF | 09.11.09 | | |
|-------------|-------------------------------|---|--|---------------|---|--|--|
| В | D6101-0 ADD 0.6 R0.031. | 015 WAS D610: 615. ZN D6-1; A ZN B5-2; 0.75 | 2-015. ZN A7-1; ADD 0.648. ZN D7-1; DD 0.125. ZN D7-2; ADD 0.060 & WAS 0.728. ZN C7-2 | RF | 09.06.30 | | |
| A NEW ISSUE | | | | RF | 09.03.30 | | |
| REV. | | | DESCRIPTION | BY | DATE | | |
| DESIG | 4 | . RF | DART AEROSPAC | E USA | INC | | |
| DRAWÎ | DRAWN RF | | PORT HADLOCK, WA | | | | |
| CHECK | ED | W | DRAWING NO. | | REV. C | | |
| MFG. APPR. | | Cul | D3883 | • | SHEET 1 OF 2 | | |
| APPRO | APPROVED 1 | | TITLE | | SCALE | | |
| DE APPR. | | | OUTBOARD SADDLE NTS | | | | |
| DATE | 09.1 | 1.09 | COPYRIGHT © 2009 BY DART AE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLE NOT TO BE USED FOR ANY PLAYOSE OR COPED OR COMMUNICATION OF THE PRIVATE PROPERTIES OF A POWER OF THE PRIVATE PROPERTIES OF A POWER ON THE PRIVATE PRIVATE PROPERTIES OF A POWER ON THE PRIVATE PRI | DON THE EXPRE | SS CONDITION THAT IT IS HER PERSON WITHOUT | | |

